



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3407-1
Job Sheet 173730



Part No: D3407-1

Job Qty: 30 ea

Part Name: Stem



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC IPP REV:D 17.11.02 AS PER DWG REV.G DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		3/22/18	0.00	0.00	Start Up Machining-2		<i>18/03/23</i>
100	Doosan	30 pcs		3/23/18	0.00	12.05	Doosan		<i>18/03/23</i>
110	QC	30 pcs		3/23/18	0.00	0.00	QC2 Machining-2		<i>18/03/23</i>
120	QC	30 pcs		3/23/18	0.00	0.00	QC8 Machining-2		<i>18/03/23</i>
130	Packaging	30 pcs		3/23/18	0.00	0.00	Packaging3-1		<i>18/03/23</i>
140	QC21-SA	30 Ea		3/23/18	0.00	0.00	QC21		<i>18/03/26</i>

Part Op 100 - 1-Turn as per Folio FA596 Rev: ____ & Dwg D3407 Rev: ____ Mill slot width at max tolerance .260"
Descriptions: 130 - LOCATION: WA001

21
9-80

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.750	17-4 Round Bar .750	13.7700 ft (.459 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-R0.750	14	44	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.063Inches $\pm$ 0.010	0.073 0.053		
2	Tow Ring	0.26520Inches $\pm$ 0.00160 - 0.00170	0.26680 0.26350		1/4-28 UNF
3	Tow Ring	0.24575Inches $\pm$ 0.00325	0.24900 0.24250		Major
4	Tow Ring	0.625Inches $\pm$ 0.010	0.635 0.615		
5	Tow Ring	0.363Inches $\pm$ 0.010	0.373 0.353		
6	Tow Ring	0.750Inches $\pm$ 0.010	0.760 0.740		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

7	Tow Ring	0.100Inches ± 0.010	0.100	0.110 0.090	Radius
8	Tow Ring	0.470Inches ± 0.010	0.470	0.480 0.460	
9	Tow Ring	0.500Inches ± 0.010	0.500	0.510 0.490	
10	Tow Ring	3.25Inches ± 0.01	3.25	3.26 3.24	
11	Tow Ring	4.250Inches + 0.000 - 0.010	4.244	4.250 4.240	
12	Tow Ring	5.270Inches ± 0.010	5.269	5.280 5.260	
13	Tow Ring	0.150Inches ± 0.010	0.151	0.160 0.140	
14	Tow Ring	0.550Inches ± 0.010	0.552	0.560 0.540	
15	Tow Ring	0.625Inches ± 0.010	0.625	0.635 0.615	
16	Tow Ring	0.250Inches + 0.010 - 0.000	0.258	0.260 0.250	

Plex 3/6/18 1:19 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition																			
				Completed By																			
				Lead hand / Supervisor Approval Verification																			
				QC / QA Coordinator Approval																			

FAULT CATEGORY

Defect Complete/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/23/18



Container No: S054340
Part: D3407-1
Job No: 173730
Serial No/Batch: S054340
Revision: G
Inspector: